



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6522A00231-W142AK-

3T

Job Sheet 199561



Part No: RBW6522A00231-W142AK-3T **Job Qty:** 5 pcs

Part Name: Tail Rotor Gear Box/Mast Output Oil Seal Assembly Press Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/28/19

Job Tracking No:

Due Date: 9/11/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBW6522A00231-W142AK-3T Rev 1 IPP Rev A 18.02.07 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	5 pcs	9/11/19	9/11/19	0.00	0.50	Bandsaw - 1		
120	SL-2500Y - 2 - B4B	5 pcs	9/11/19	9/11/19	1.00	2.50	SL-2500Y -1 - B4B		
130	QC 2	5 pcs	9/11/19	9/11/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Container No: S213754



Part: RBW6522A00231 - W142AK - 3T

Job No: 199561

Serial No/Batch: S213754

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 08/14/19

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					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
140	QC 8	5 pcs	9/11/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	on 19/09/16
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
170	Outsource - 12 - Black Oxide	5 pcs	9/11/19	0.00 0.00	Gr0002	2019-09-17
180	Packaging 2-1 - Receive - B4B	5 pcs	9/11/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
190 QC 6	5 pcs	9/11/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	DAS
					QC 6 - 40	81
					QC 6 - 81	9-89
						SEP 25 2019
200 Packaging 3-1 - Stock - B4B	5 pcs	9/11/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	DAS
					Packaging 3 - 7 - B4B	28
					Packaging 3 - 8 - B4B	9-89
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
210 QC 21 - SA	5 pcs	9/11/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	DAS
					QC 21 - SA - 53	21
						SEP 26 2019

Part Op 100 - (Bandsaw) CUT BLANKS TO 2.95" ^{575"}

Descriptions: 120 - (MORI SL2500Y LATHE) 1-Machine as per DWG. FC966 FOLIO REV: 1/1A DWG REV: 1

2-Deburr 3-Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

130 - (QC2- Inspect parts off machine FAI/FAIB)

140 - (QC8- Inspect parts - second check)

170 - (Outside Processing - Black Oxide) -Issue P/O to Groupe Aitech; PO 44523 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

180 - (Receive & Inspect for Damage & Mat'l Certs)

8/28/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

190 - (QC6- All purchased or subcontracted products)

200 - (Identify as per dwg & Stock Location:_____)

210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-1144-R3.500	AISI 1144 Stressproof Round Bar 3.500"	.1000 ft (.02 ea)	100-Bandsaw - 1	5045278

24411/pc

DAS
45
19-9-6
9-896x275
16

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	MT-1144-R3.500	0	9	0

Part Specifications

Specifications could not be found.

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This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED MISSING 1.5 DIM. AND FEATURE CONTROLS TO #3.4251-3.4204 & #3.1740-3.1692 DIMS	9/28/12	RJC	SE

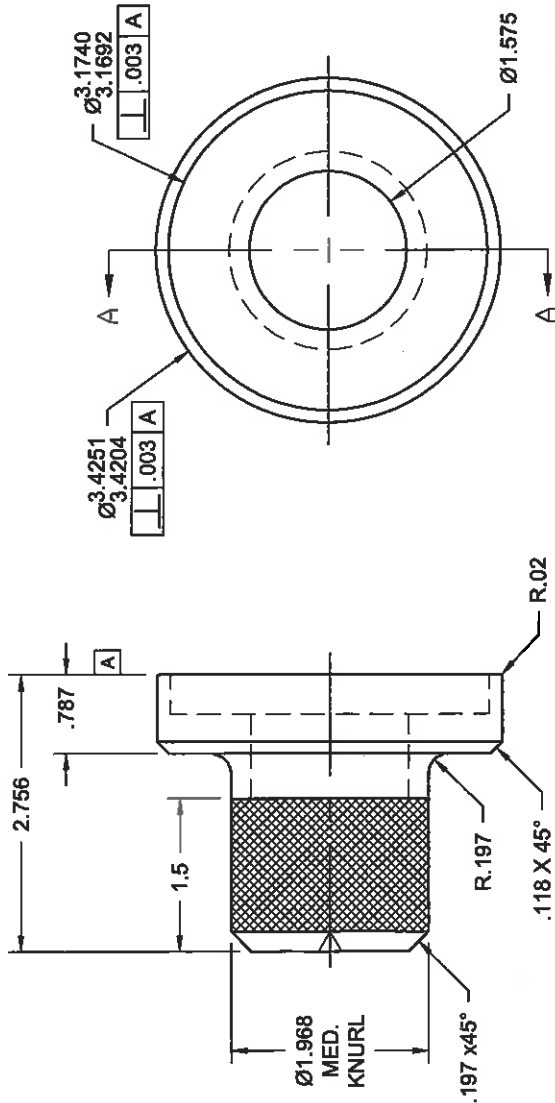
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WORK ORDER

195361 M15

190828



ENGRAVE TOOL No.
"RBW6522A00231-W142AK-3T",
S/N, "MADE IN USA"

SECTION A-A

NOTES

1. ALSO SOLD IN KIT RBW6505G00231-3T.

RED BARN MACHINE	
TITLE	OUTPUT OIL SEAL PRESS TOOL
DWG NO.	RBW6522A00231-W142AK-3T
REV	1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	FRACTIONS ± 1/32
XXX ± .005	ANGLES ± 5°
XX ± .01	
X ± .1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: PERRITT	
APPROVED: D. H. H.	
TREAT: BLACK OXIDE	
SPEC:	
USED ON MODEL: AW139	
SCALE: NTS	
DATE: 1-3-09	
SHEET: 1 of 1	

ASSY	QTY	BIO	PART #	UNIT	DESCRIPTION	MATERIAL	SP	Pg.
	1				PRESS TOOL			Ø3-1/2 X 2-7/8

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



DISPOSITION		DEPARTMENT/PROCESS							
Job: _____	Rework ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐				
Part No. _____	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐				
	Use-as-is ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐	Quality ☐			
Date: _____	Sequence #: _____	QTY Affected: _____							
Description Work Order Deviation		Disposition							
		Completed By							
		Lead hand / Supervisor							
		QC / QA Coordinator							
Root Cause		FAULT CATEGORY							
Operator ☐		Pressure/Forced ☐		Contamination ☐		Power Loss/Surge ☐		Positioned Wrong ☐	
Manufacturing Process ☐		Bending ☐		Misaligned/off center ☐		Folio/Program ☐		Outside Tolerance ☐	
Equip/Tooling ☐		Crushing ☐		BOM/Route ☐		Grain Direction ☐		Drawing ☐	
Handling/Preservation ☐		Cracks ☐		Broken/Damage/Defect ☐		Weld ☐		Finish ☐	
Material ☐		Crimp/Kink/Ripple/Wave/Twist ☐		Incomplete/Unclear Instructions ☐		Wrong Stock Pulled ☐		Part Lost/Missing ☐	
Product Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Out of Sequence ☐		Misread ☐	
Process Improvement ☐		Mislabeled ☐		Fit/Function ☐		Off-set/Set-up ☐			
Human Factors ☐		Other/Details: _____							



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K6A 1K7
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PURCHASE ORDER

POHB044523



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044523

PO Date: 9/17/19

Due Date: 9/25/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-09-20

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	198284	RBT18635-3	Spud -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	-	9/25/19	4 pcs	0 pcs	4 pcs	\$5.96/pcs	\$23.84
2	198282	RBT18635-1	Adapter Bushing -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	-	9/25/19	4 pcs	0 pcs	4 pcs	\$0.99/pcs	\$3.96



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PURCHASE ORDER

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Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	200410	RBW5605G00551-3G-1	Shoe -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	9/25/19	1 pcs	0 pcs	1 pcs	\$1.11/pcs	\$1.11
4	198052	RBW6405G04132-3G-6	Rod -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Stress Proof -Certificate of Conformity is required	Firmed	-	9/25/19	5 pcs	0 pcs	5 pcs	\$9.90/pcs	\$49.50
5	196252	RBSC7028-P-5	Cutter Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	9/25/19	10 pcs	0 pcs	10 pcs	\$2.87/pcs	\$28.70



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PURCHASE ORDER

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Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	199561	RBW6522A00231-W142AK-3T	Tail Rotor Gear Box/Mast Output Oil Seal Assembly Press Tool (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	9/25/19	6 pcs	0 pcs	6 pcs	\$8.43/pcs	\$50.58
7	196076	RBW5605G00251-3G-3	Handle -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required	Firmed	-	9/25/19	1 pcs	0 pcs	1 pcs	\$1.51/pcs	\$1.51
8	196078	RBW5605G00351-3G-3	Handle -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Tool steel -Certificate of Conformity is required	Firmed	-	9/25/19	1 pcs	0 pcs	1 pcs	\$1.48/pcs	\$1.48



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Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
9	196079	RBW5605G00551-3G-3	Handle -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Tool steel -Certificate of Conformity is required	Firmed	-	9/25/19	1 pcs	0 pcs	1 pcs	\$1.41/pcs	\$1.41
Grand Total:										\$162.09	

Order Notes

Procurement Quality Clauses
 A005 right of entry
 A012 chemical and physical test report
 A016 personnel qualification
 A017 raw material identification (as applicable)

A022 Apical Processing
 A024 process certifications
 A026 certification of material conformance

A041 quality management system
 A042 dart notification by supplier
 A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/20/19 11:02 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(022506-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

022506 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
23-Sep-2019		SPARTAKOS BOUNTOURIS		POHB044523				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
3	RBW5605G00551-3G-1 Rev.	RBW5605G00551-3G-1 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE3 CLASS 1 WIPE OFF EXCESS OIL	OXIDE-BLACK CH	1	1	0	0	0
5	RBSC7028-P-5 Rev.	RBSC7028-P-5 OXIDE BLACK [OXIDE BLACK] AS PER MIL-C-13924C CLASS 1	OXIDE-BLACK CH	10	10	0	0	0
6	RBW6522A00231-W142AK-3T Rev.	RBW6522A00231-W142AK-3T OXIDE BLACK [OXIDE BLACK] AS PER MIL-C-13924C CLASS 1	OXIDE-BLACK CH	6	6	0	0	0

DAS
81
9-89

RECEIVED
 SEP 23 2019
 DART AEROSPACE LTD

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.